A1 .3126 W.058

Quality Control

A

Work Order ID 73393 Wednesday, August 31, 2011 3:04:02 PM												Page 1
Revision ID:	D3275-1			Accept				s	_	Start Stop	.,	
	Crossbolt Spac 8/31/2011 9/16/2011	Start Qty: 160.00 Req'd Qty: 160.00			Cust Item II Customer:	D:			,	Stop		
Approvals:	Process Pla		Date: 11/08/3 Date:	Tooling: SPC (Y/N):	Da			R		Start Stop		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	······································	ision Nbr										
D3275 100 Hardinge Hardinge CNC Lath	Rev e Small	Hardinge CNC LATHE	SMALL er Folio FA469 and Dwg D3	0.00 0.00 275	L:1/09/23			160	<u>-</u>	%	MIT I	
110 QC Quality Control		QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00	Rido9/23			161	ĺ	<u>~</u>		
120		QC8- Inspect parts - sec	ond check	0.00 SL	11-09-23							

0.00

Memo

W/O:			W	ORK ORDER CHANG	SES		***	,,,,	
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							1	r rod wigi	
Dout No.		222	Fred Octo		NOD V	N		D.4	
Part No		PAR #:							
	K	esolution:						Date: _	
NCR:	,		WORK ORD	ER NON-CONFORM		4)		· <u>-</u> .	
DATE	STEP	Description of NC	Corrective Action Initial Action Descr		Section B ption Sign &		cation		Approval
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspector
									

Work Order ID 73393

Wednesday, August 31, 2011 3:04:02 PM



Page 2

Item ID:

D3275-1

Accept



Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Required Date: 9/16/2011

Crossbolt Spacer

8/31/2011

Start Qty: 160.00

Req'd Qty: 160.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop



Sequence ID/

Work Center ID

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location \$.

Memo

Set Up/

Run Hours

0.00

0.00

STOCK IN SKIDTUBE CELL

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Run

Reject Number

Insp. Stamp

140

130

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11-09-26

W/O:			ES		***								
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				

							·						
Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date: _					
		esolution:											
NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC Corrective Action			Section B Ve			Approval	Approval				
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		tion C	Chief Eng	QC Inspector				
									·				

Picklist Print

Wednesday, August 31, 2011 3:03:59 PM

Work Order ID: 73393

13393

Parent Item: D3275-1

Parent Item Name: Crossbolt Spacer



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 160.00

Required Qty: 160.00

Comments:

IPP Rev:A□04.10.19□New issue□KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05		Purchased	No			100	f	164.5390	0.2666	44.90105			

ALUM TUBE .3125 x .058w

Location	Loc Qty
MAT013	164.539
116793	1.667
116939	23.972
117400	28.9
118438	110

Loc Code

Page 1

-	oopaoc								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						<u> </u>			
							;		
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes I	No DQA:	•	Date: _	1
	Re	solution:	Dispositi	on:	_ QA: N/C Cld	sed:		Date: _	
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (NCR)		., .,	
DATE	OTED	Description of NC			on B	Verifica	ation	Approval	Ápproval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector



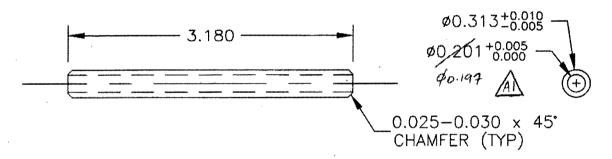


DESIGN	P	DRAWN BY	DART /	AEROSPACE PORT HADLOCK,	
CHECKED	A.A	APPROVEO	DRAWING NO.		REV. A
٥	#一	#	D3275		SHEET 1 OF 1
DATE		<u> </u>	TILE	· · · · · · · · · · · · · · · · · · ·	SCALE
04.03.1	0		CROSS BOL	T SPACER	1:1
Α	ıJ	04.03.10	NEW ISSUE		
AI G	#	04.10.19	CHANGE M	MT'L SPEC	



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 73393

CZ11/08/3/



D3275-1 CROSS BOLT SPACER

1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6R) M6061T6T0 313W.058 AN

2) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

	•								
W/O:			W	ORK ORDER CHANGE	ES				•
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							•		
							1 ,		
Part No	·	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	QA: N/C CI	osed:		Date: _	
NCR: WORK ORDER NO				ER NON-CONFORMA	NCE (NCF	R)		-	
DATE	STEP	Description of NC		on B		cation	Approval	Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
			·						

DART AEROSPACE LTD	Work Order:	73393
Description: Crossbolt Spacer	Part Number:	D3275-1
Inspection Dwg: D3275 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	,
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.180	+/-0.010	3.182	_		Vern Mt	06
0.025 - 0.030	N/A	.030	_		,7	
45°	+/-0.01°	450			, 1	
Ø0.313	+0.010/-0.005	D.311	_		tı.	
0.058	Max = 0.0605 Min = 0.0555	.05%			ι,	
						,
						·

Measured by:	and	Audited by:	Prototype Approval:	N/A
Date:	11/09/23	Date: 1-03-23	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α.	04.10.19	New Issue	KJ/JLM	
В	06.03.09	Dimension Ø0.197 was Ø0.201	KJ/JLM ,	П
С	09.05.04	Ø0.197 dimension removed	KJ/DD	
	·			

									_
W/O:			WC	RK ORDER CHANGE	S				•
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cate	NCR: Yes No DQA: Date:					
Resolution:			Disposition	QA: N/C Clo	A: N/C Closed: Date:				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Approx		Approval	al Approval
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			Chief Eng	QC Inspector
		,							
		·							
1	i		1					1	1